

DART AEROSPACE LTD	Work Order:	22339
Description: Fuel Purge Canister	Part Number:	D3262-041
Dwg: D3262 Rev. A	Qty:	2 4
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) D3262-041 consists of (1) D3262-1; (2) D3262-3	HA	05.02.01	4
2	MV	Cut (2) blanks per (1) D3262-041 Cut blanks: 6.000" x 0.500" x 5.400" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B0.500x06.000) Identify for D3262-3 Batch: <u>M9218</u>	BE	05.02.02	5
3	MV	Machine as per Folio FA457 and Dwg D3262 Identify as D3262-3	BE	05.02.02	5
4	QC2	Inspect parts as they come off the CNC machine	BE	05.02.02	5
5	QC8	Second check	BE	05.02.07	5
6	MV	Deburr	BE	05.02.07	5
7	MV	Cut D3262-1 to length as per Dwg D3262 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) Identify as D3262-1 Batch: <u>M15362</u>	DA	05/22/09	2
8	WA	Weld canister assembly as per Dwg D3262 using DT8739 to align fillings Pick: Qty Part Number Description Batch A/R Aluminum Rod <u>M15079</u>	DA	05/02/09	4
9	QC5	Inspect work to Step 8	DA	05.02.22	
10	PG	Issue P/O: For Liquid Penetrant inspection as per Dwg D3262, QSI 038 & as per ASTM E1417 Level 1 Possible Supplier: NDT Copy of NDT results is required.			
11	RG	Receive and inspect for transit damage Ensure copy of NDT results are attached.			
12	QC6	Inspect for damage and ensure results are as per Dwg D3262 Pressurize to 10 psi and submerge under water to check for leaks			
13	FP	Chemical Conversion Coat as per QSI 005 4.1	MA	05.02.12	2
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 Ensure to mask threads	MA	05.03.03	2
15	QC3	Inspect Powder Coat	CA	05/03/04	2
16	ST	Identify with Dart part number and batch number using a fine point permanent ink marker, then Stock	CA	05/03/04	2
17	AC	Cost / part: <u>217.33</u>	595	05.03.18	2
18	DC	Close W/O <u>159.60</u> Inspect Level 21	HA	05.03.18	2

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	
B	04.09.29	Added Steps 10-12; changed Step 16	KJ/JLM	

RELEASED

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
02.05.22	10, 11 & 12	CHANGE PROCEDURE AS PER DWG. D3262 REV. B	<i>[Signature]</i>	05.03.18	N/A	<i>[Signature]</i> 05.02.22	<i>[Signature]</i> 05.02.22	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-03-14	12	3 pieces scrap new product	<i>[Signature]</i> 12-03-14	destroy	<i>[Signature]</i> 05-03-14	<i>[Signature]</i> 05-03-14	<i>[Signature]</i> 12-03-14	<i>[Signature]</i> 05-03-14

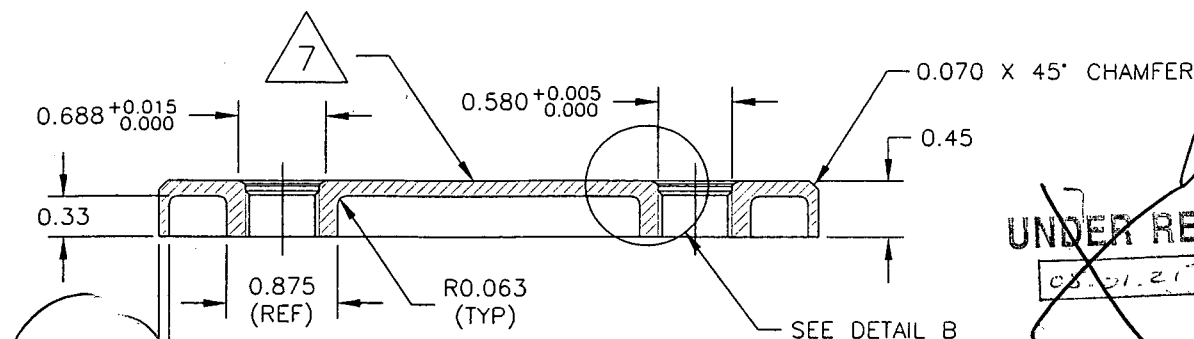
Part No: D3262-041 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 05/03/18

NOTE: Date & initial all entries

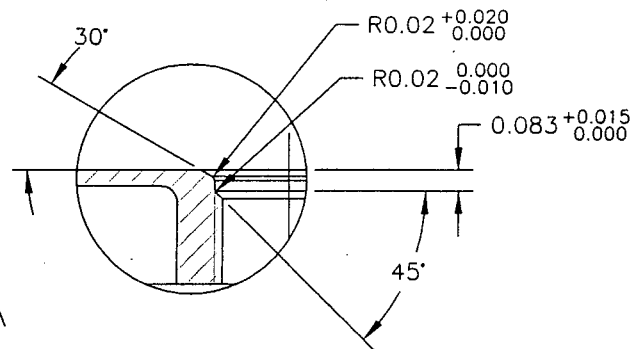
QA: N/C Closed: _____ Date: _____



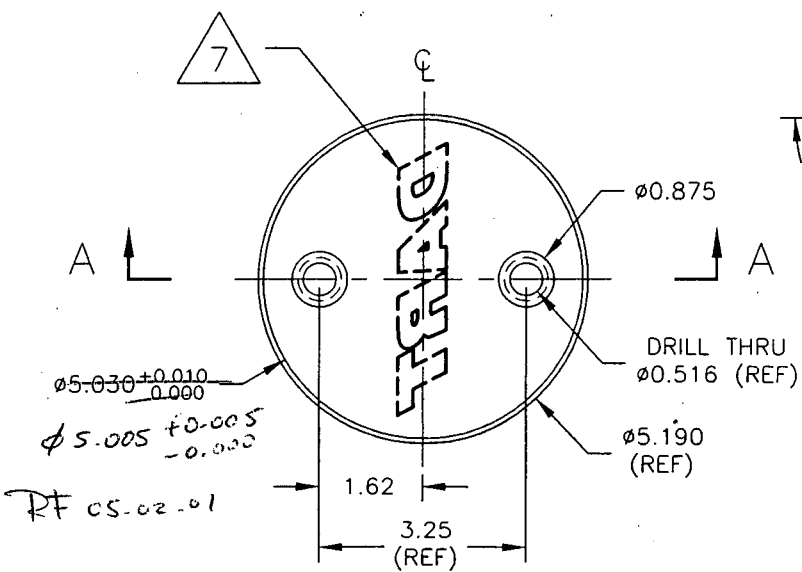
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED RF	DRAWING NO. D3262	REV. A SHEET 2 OF 2
DATE 04.05.06	TITLE FUEL PURGE CANISTER	SCALE 1:3	



SECTION A-A
SCALE 2:3



DETAIL B
SCALE 4:3



D3262-3 CAP

RELEASED
04.07.09 RF

D3262-3

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH X 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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WITHOUT NOTICE

WORK ORDER
NO. 22339



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	

~~RELEASED~~
04.05.06

D3262-1 TUBE

~~UNDER REVIEW~~

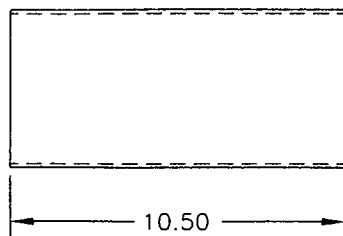
(TYP) >0.13

FITTING HOLES
IN LINE

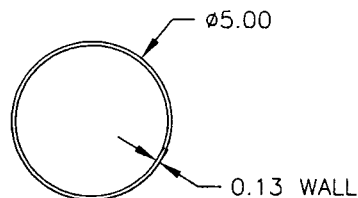
D3262-3 CAP
(TYP)

10.88
(REF)

D3262-041 CANISTER ASSEMBLY



D3262-1 TUBE



D3262-041:

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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WORK ORDER
NO. 22339

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 01, 2005
10:05 am

Work Order No : 0022339
Project Name : D3262-041
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : D3262-041
Description : Fuel Purge Canister
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 02-01-05
Est Finish Date : 02-04-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00